

Date: Wednesday, 6/6/2007 2:01:52 PM
 User: Kim Johnston

spit u/o SB 07/08/27/26

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	PEDAL ASSEMBLY		
Job Number	32814			Part Number	D412704041		
Estimate Number	11005			Drawing Number	D412-704-041 REV A		
P.O. Number	N/A			Project Number	N/A		
This Issue	6/6/2007	S.O. No.	N/A	Drawing Revision	A		
Prsht Rev.	NC			Material	N/A		
First Issue	N/A			Due Date	6/26/2007		
Previous Run	29896			Qty:	5	Um:	Each
Written By	<i>dkj</i> 07.06.07						
Checked & Approved By							
Comment	Est Rev:B 05.01.28 Removed hardware on Step 2; Added Figures 1-3 KJ/RF Est Rev:C 06.03.08 Re-format EC Est Rev:D 07-03-20 Added Dwg D412-704-041 07-03-20 JLM Est Rev:E 07.05.02 Reformat EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:			Description :						
1.0	D3204041			Pedal Assembly						
Comment:	Qty.: 1.0000 Each(s)/Unit			Total : 6.0000 Each(s)						
Pick:	Qty	Part number	Description	batch	<i>B 30829 X1</i>					
	1	D3204-041	Pedal Assembly		<i>X 5</i>					
2.0	D32051			Bracket						
Comment:	Qty.: 1.0000 Each(s)/Unit			Total : 6.0000 Each(s)						
Pick:	Qty	Part number	Description	batch	<i>B 30830 X4</i>					
	1	D3205-1	Bracket		<i>B 28941 X2</i>					
3.0	D32053			Back Plate						
Comment:	Qty.: 1.0000 Each(s)/Unit			Total : 6.0000 Each(s)						
Pick:	Qty	Part number	Description	batch	<i>32823 X5</i>					
	1	D3205-3	GHW Bracket		<i>B 28942 X1</i>					
4.0	D32061			Pedal Arm						
Comment:	Qty.: 1.0000 Each(s)/Unit			Total : 6.0000 Each(s)						
Pick:	Qty	Part number	Description	batch	<i>B 29915 X6</i>					
					<i>(-1) ✓ ml 07/01/20</i>					

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/08/27	13	Split W/O			SB	07/08/27	5		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 6/6/2007 2:01:52 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL ASSEMBLY

Job Number: 32814

Part Number: D412704041

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 D3206-1 Pedal arm

5.0 D3209041 Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part number Description
1 D3209-041 Bracket

batch

B23194 X2
B30832 X4

(-1) ✓

ml

6.0 AN310A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part number Description
1 AN3-10A Bolt

batch

M17566

(-1)

✓

ml

7.0 AN3154R Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part number Description
1 AN315-4R Nut

batch

M17566

(-1)

✓

ml

8.0 AN410A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part number Description
1 AN4-10A Bolt

batch

M101291

(-1)

✓

ml

9.0 AN412A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part number Description
2 AN4-12A Bolt

batch

M104547

(-2)

✓

ml07/07/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 6/6/2007 2:01:52 PM
User: Klm Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL ASSEMBLY

Job Number: 32814

Part Number: D412704041

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0 MS24694S102 Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	MS24694S102	Screw	<u>m14604</u>

(-1)

✓

ml

17.0 MS951910 Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	MS9519-10	Bolt	<u>m100290</u>

(-1)

✓

ml 07/07/20

(P) →

X5

18.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble pedal as per Dwg D412-704-041

Tighten & Torque Bolts as per Dwg D412-704-041

ml 07/08/28

19.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

EP 07/08/28 (+4)

20.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0 AN960JD10L Washer



E 07/08/28 Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty	Part number	Description	batch
4	AN960JD10L	Washer	<u>M103044-</u>

J.S.



J.S. 07/09/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/09/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/09/04	# 180	one PEDAL PEDAL sensor Pedal Arm weldment (D3204-041) Bends with D3205-1 found during inspection RC D3204-041 looks like it was squashed when Bushing was pressed in.	/ aswz	sign D3204-041 Remove all hardware and Re-lable with Batch and Part #'s.	SAC 07/09/06 6AS 07/09/06	/ er 07/09/06	/ pos1042	/ cm 07/09/06

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Drawing Name: PEDAL ASSEMBLY

Job Number: 32814

Part Number: D412704041

Job Number:



Seq. #: Machine Or Operation:

Description :

22.0 AN36A Bolt



EP



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part number Description
2 AN3-6A Bolt

M100184

23.0 MS21042L3 Nut



EP



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

Batch: *M1041936*

EP 07/09/10

24.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

EP 07/09/10 X4

25.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

EP 07/09/10

26.0 QC21 FINAL INSPECTION/W/O RELEASE



EP 07/09/10

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 07/09/11

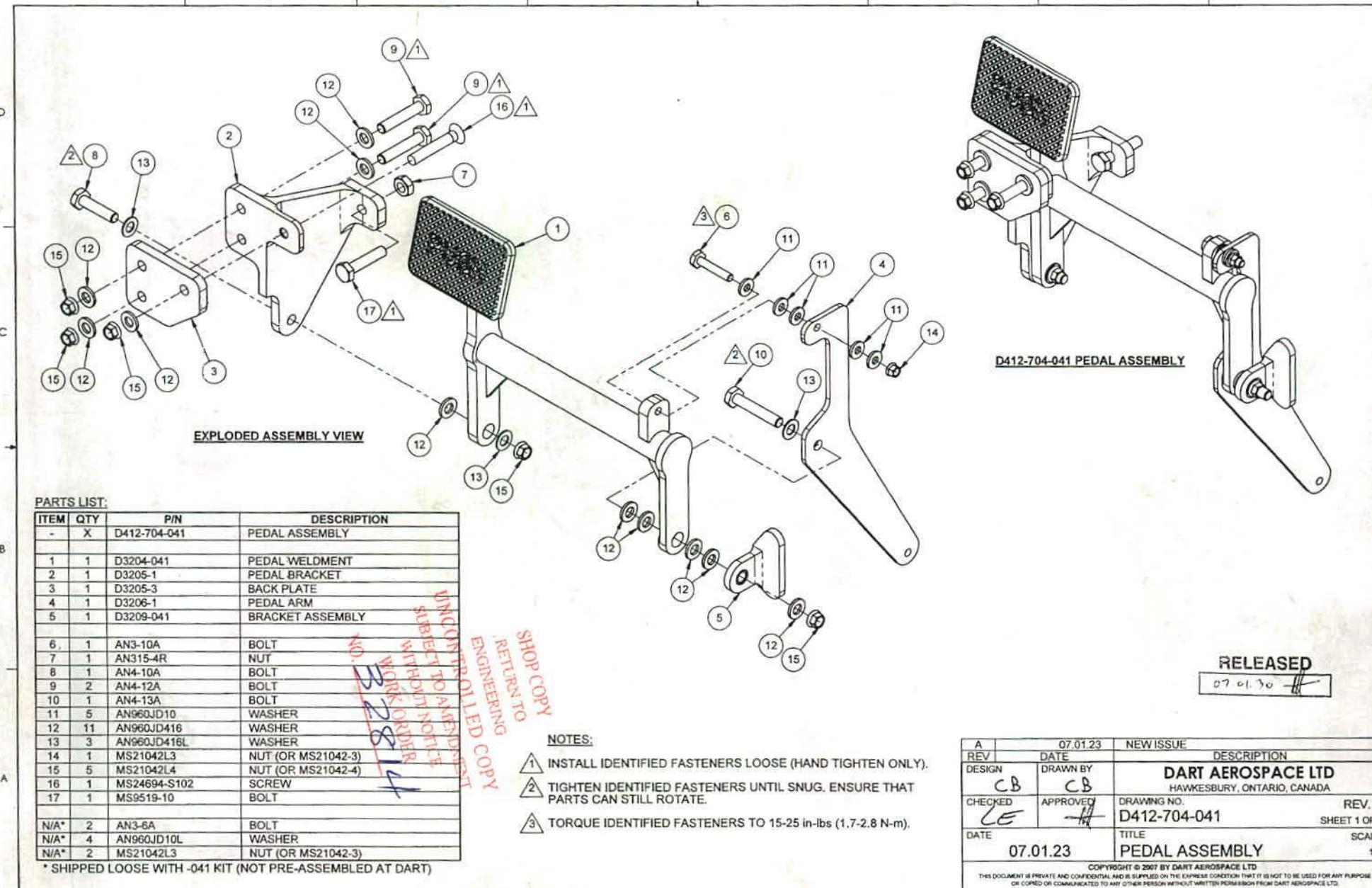
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



* SHIPPED LOOSE WITH -041 KIT (NOT PRE-ASSEMBLED AT DART)